



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5380-3
Job Sheet 185917



Part No: D5380-3

Job Qty: 10 pcs

Part Name: Support Base



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/6/18

Job Tracking No:

Due Date: 11/22/18

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV C SHEET 3 IPP Rev: A New issue JFS 16/02/03 Verified by: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
100	HAAS 4 Axis	10 pcs	11/22/18		0.00	14.29	HAAS - 1	
							HAAS - 2	
							HAAS - 3	
							HAAS - 4	<i>[Signature]</i>
110	QC 2	10 pcs	11/22/18		0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	<i>[Signature]</i>
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	



Container No: S147806



Part: D5380-3

Job No: 185917

Serial No/Batch: S147806

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

DART Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/04/19

				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
120	QC 8	10 pcs	11/22/18	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 38
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
121	QC 5	10 pcs	11/22/18	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 38
					QC 5 - 42
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
130	Packaging 3-1 - Stock - B4B	10 pcs	11/22/18	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B

19/02/12

~~QC 8 - 8~~ ~~QC 8 - 9~~ ~~QC 8 - 68~~

DAS
40
9-89
DAS
9
9-89

19/03/04

					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	LG056 A8 19-3-5
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	MAR 05 2019
140	QC 21 - SA	10 pcs	11/22/18	0.00 0.00	QC 21 - SA - 21	DAE 21 8-05
					QC 21 - SA - 70	
Part Op 100 - HAAS1-2 (HAAS CNC Vertical Machine) Machine as per Folio FB460 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 121 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: _____) LOCATION : LG0546 140 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
D5380-3TRN	Support Base Turnng Detail	5 pcs (.5 ea)	100-HAAS 4 Axis			
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-HAAS 4 Axis	D5380-3TRN	5	5	0		
Part Specifications						
Specifications could not be found.						



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D5380-3**Job Sheet 185917****Part No:** D5380-3**Job Qty:** 10 ea**Part Name:** Support Base**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/6/18**Job Tracking No:****Due Date:** 11/22/18**Created By:** Jesse White**Type:** Stock**Description:****Note:** DWG REV C SHEET 3 IPP Rev: A New issue JFS 16/02/03 Verified by: DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/22/18	11/22/18	0.00	0.00	Start Up Machining-4		
100	CNC Vertical Machining	10 pcs	11/22/18	11/22/18	0.00	14.29	HAAS1-2		
110	QC	10 pcs	11/22/18	11/22/18	0.00	0.00	QC2 Machining-4		
120	QC	10 pcs	11/22/18	11/22/18	0.00	0.00	QC8 Machining-4		
121	QC	10 pcs	11/22/18	11/22/18	0.00	0.00	QC5		
130	Packaging	10 pcs	11/22/18	11/22/18	0.00	0.00	Packaging3-2		
140	QC21-SA	10 Ea	11/22/18	11/22/18	0.00	0.00	QC21		

Part Op **100** - Machine as per Folio FB460
Descriptions: **130** - LOCATION : LG054

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5380-3TRN	Support Base Turnng Detail	5 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5380-3TRN	5	0	0

Part Specifications

Specifications could not be found.

Plex 11/6/18 1:13 PM dart.white.jesse

DART AEROSPACE LTD		Work Order: 185917
Description: Support Base		Part Number: D5380-3
Inspection Dwg: D5380	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	3.890	3910		3.901	3.901	3.997	3.894	3.900
AB	0.256	0.263		0.257	0.257	0.256	0.256	0.256
AC	3.540	3.560		3.557	3.557	3.546	3.547	3.547
AD	1.765	1.785		1.766	1.776	1.775	1.775	1.774
AE	0.590	0.610		0.600	0.600	0.594	0.599	0.596
AF	1.140	1.160		1.150	1.150	1.150	1.150	1.150
AG	2.290	2.310		2.300	2.300	2.297	2.297	2.296
AH	0.490	0.510		0.500	0.500	0.499	0.494	0.497
AI	0.115	0.135		0.125	0.125	0.128	0.128	0.125
AJ	0.240	0.260		0.250	0.250	0.252	0.252	0.250
AK	0.140	0.160		0.150	0.150	0.150	0.150	0.150
AL	1.502	1.522		1.520	1.521	1.522	1.522	1.522
AM	0.100	0.125		0.110	0.110	0.109	0.108	0.108
AN	0.053	0.073		0.063	0.063	0.063 R	0.063 R	0.063 R
AO	0.220	0.280		0.250	0.250	0.250 R	0.250 R	0.250 R
AP	0.220	0.280		0.250	0.250	0.250 R	0.250 R	0.250 R
AQ	0.170	0.230		0.200	0.200	0.200	0.200	0.200
AR	0.010	0.030		0.020	0.020	0.020	0.020	0.020
AS								
AT								
AU								
AV								
AW								
AX								
AY								
AZ								
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject								

Measured by: MM	Date: 20/01/24
Audited by: [Signature]	Date: 19/02/24
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	[Signature]

DART AEROSPACE LTD		Work Order: 185917
Description: Support Base		Part Number: D5380-3
Inspection Dwg: D5380	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	10
HAAS Section								
AA	3.890	3910		3900	3900	3901	3902	3902
AB	0.256	0.263		.256	.256	.256	.256	.256
AC	3.540	3.560		3.547	3.546	3.546	3.550	3.550
AD	1.765	1.785		1.772	1.771	1.772	1.772	1.772
AE	0.590	0.610		.597	.597	.597	.596	.597
AF	1.140	1.160		1.150	1.150	1.150	1.150	1.150
AG	2.290	2.310		2.296	2.297	2.297	2.297	2.297
AH	0.490	0.510		.498	.497	.497	.496	.496
AI	0.115	0.135		.125	.125	.125	.125	.125
AJ	0.240	0.260		.250	.250	.250	.250	.250
AK	0.140	0.160		.151	.150	.150	.150	.150
AL	1.502	1.522		1.522	1.522	1.522	1.522	1.522
AM	0.100	0.125		.107	.107	.107	.107	.107
AN	0.053	0.073		.063 R	.063 R	.063 R	.063 R	.063 R
AO	0.220	0.280		.250 R	.250 R	.250 R	.250 R	.250 R
AP	0.220	0.280		.250 R	.250 R	.250 R	.250 R	.250 R
AQ	0.170	0.230						
AR	0.010	0.030		.020	.020	.020	.020	.020
AS								
AT								
AU								
AV								
AW								
AX								
AY								
AZ								
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject								

Measured by: M.M.	Date: 2019/01/24
Audited by: [Signature]	Date: 19/02/12
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	[Signature]